

Work Order ID 129324

February-03-15 11:48:59 AM

129324

Page 1

Item ID: D3602-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Angle

Start Date: 2/03/15 Start Qty: 50.00 *50* Cust Item ID:
 Required Date: 2/20/15 Req'd Qty: 50.00 *50* Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3602	Rev B

105 0.00

105

Purchasing Memo 0.00
 Purchasing ISSUE PO TO GFI 27329
 MAKE PER DRWG D3602 REV.B

MLJ 15-02-03 (50)

115 Receive & Inspect for Damage & Mat'l Certs 0.00

115

Packaging Memo 0.00
 Packaging

50X 2015-03-6

125 QC6- Inspect dimensions to drawing 0.00

125

QC Memo 0.00
 Quality Control

DAS
 38
 9-89
 (50)

APR 08 2015

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129324

Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>st 201</u>	0.00		SG	DAS	27			
150	Memo	0.00							
Packaging									
Packaging									
160	QC21 - Final Inspection - Work Order Release	0.00							
160	Memo	0.00							
QC									
Quality Control									

APR 09 2015

MLJ 15-04-10

AS-4-9

Picklist Print

February-03-15 11:48:59 AM

Page 1

Work Order ID: 129324

129324

Parent Item: D3602-1

D3602-1

Parent Item Name: Angle

Start Date: 2/03/15

Required Date: 2/20/15

Start Qty: 50.00

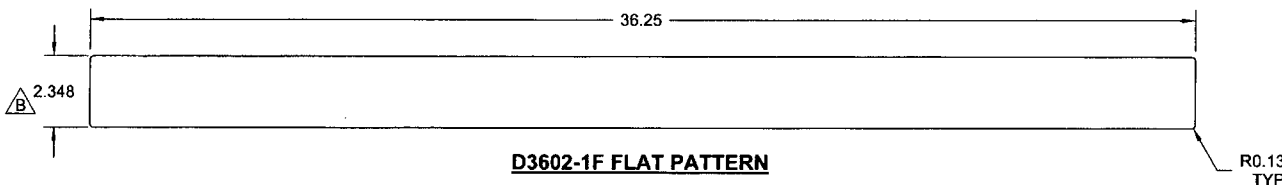
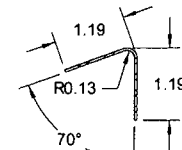
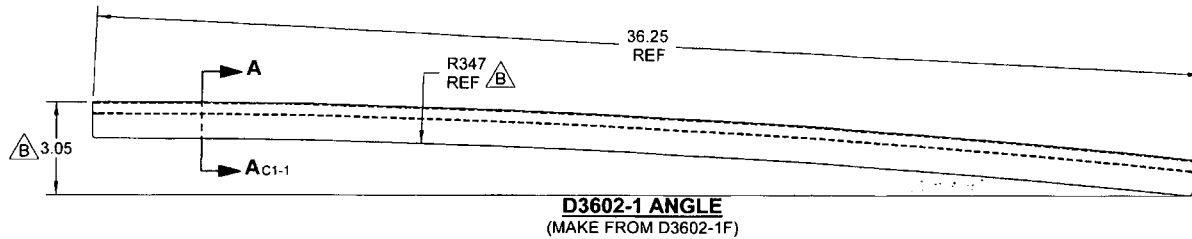
Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-27 JLM
IPP Rev:B 08-12-11 as per ECN08-577 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3602-1P		Purchased	No				Each	0.0000		50			
D3602-1P									**	50x			
Angle													

50x SP15-03-60

8 7 6 5 4 3 2 1



SUPPLY
REWORK
COPY
129324 MVS
15-02-03

RELEASED
6/23/11 MVS

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE, 0.038 THICK, PER AMS 5513 OR AMS 5524, REF. DART SPEC. M304S20GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFY WITH DART P/N "D3602-1" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.97 lbs

B	ADDED ROUNDED SHAPE: R347 REF AND 3.05; 2.348 WAS 2.328. REF: NCR#09-014	MB	09.02.02
A	NEW ISSUE	MB	07.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.02.02		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3602 TITLE ANGLE REV. B SHEET 1 OF 1 SCALE NTS COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27329**

Purchase Order Date 2/3/2015

PO Print Date 2/3/2015

Page Number 1 of 2

Order From :

VC-GFI001

Ship To : DART AEROSPACE LTD

GFI
180 AVENUE LABROSSE
POINTE CLAIRE, QC H9R 1A1
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 514 630 4877

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3602-1P AS PER DWG.D3602 REV.B B129324	Angle	3/3/2015 Yes 3/3/2015	FN	50.00 Each	\$34.00	\$1,700.00
						Line Total:	\$1,700.00
2	71401-45 PROCUREMENT QUALITY CLAUSES PROCUREMENT QUALITY CLAUSES A005 RIGHT OF ENTRY A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE) A012 CHEMICAL AND PHYSICAL TEST REPORTS A016 PERSONNEL QUALIFICATION A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE) A026 CERTIFICATION OF MATERIAL CONFORMANCE A041 QUALITY MANAGEMENT SYSTEM A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENT	PROCUREMENT QUALITY CLAUSES	3/3/2015 No 3/3/2015		1.00	\$0.00	\$0.00

SP15-03-6

Note:

2/3/2015



180 AVENUE LABROSSE
POINTE-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Limitée / GFI is a division of Thomas & Betts Limited



BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON / SHIPPING MEMO NO		PAGE
JR - DY	MO - MO	AN - YR			
05	03	15	0555557		1/1



VENDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

CODE DE CLIENT / CUSTOMER CODE		N° DE CONTRAT / JOB NO	VOTRE N° DE COMMANDE / YOUR PURCHASE ORDER NO	EXPÉDIÉ PAR / SHIP VIA
DART		GFI-0299	0298686	PO27329

QUANTITÉ / QUANTITY	N° DE PIÈCE / PART NO	DESCRIPTION
50	D3602-1P ✓	ANGLE ITEM 1 C OF C REQ'D
SP15-036 MFG. JOB# 0298686 - 001 QTY 50 pcs DUE DATE: 03 March 2015		

EXPÉDITEUR / SHIPPER

REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas&Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

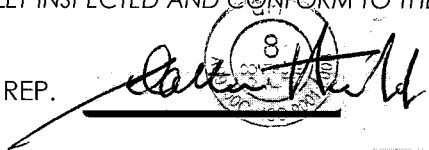
DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	<u>2</u>	OUR JOB NO	<u>0298686</u>	SHIPPING MEMO	<u>0555557</u>	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<u>1</u>	<u>50 PCS</u>	<u>PO27329</u>	<u>D3602-1P</u>	<u>B</u>	<u>ANGLE</u>	<u>B</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
<u>.040 THK AMS 5513 304 ANN</u>		<u>TW METALS/ OUTOKUMPU</u>		<u>H/N 504954</u>		

	PROCESS	PROCESSOR	RELEASE NOTE #
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>	<u>GFI</u>	<u>N/A</u>
2	<u>REF. GFI MANUFACTURING JOB NUMBER 0298686-001 (50 PCS)</u>	<u>GFI</u>	<u>N/A</u>
3	<u></u>	<u></u>	<u></u>
4	<u></u>	<u></u>	<u></u>
5	<u></u>	<u></u>	<u></u>
6	<u></u>	<u></u>	<u></u>
7	<u></u>	<u></u>	<u></u>
8	<u></u>	<u></u>	<u></u>
9	<u></u>	<u></u>	<u></u>

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 05 MARCH 2015

G.F.I. Q.C. REP. 



O'Neal High-Performance Metals Group

1 Wright Avenue - Rear
LeRoy NY 14482
Tel: 585-768-5600
FAX: 15857685601

CERTIFICATE OF COMPLIANCE

Your Order Number: 0085500

Our delivery receipt Number: 12101871

Date: 3/05/15

This is to certify that the material shipped against the above order on the above delivery receipt, consisting of:

Quantity: 65.000 LB

Line Number: 1

Grade: 304 ANNEALED AMS5513 .040

Part #: TS040481204A

Heat Number: 504954

Specification:

Complies in all respects with the item description.



BY:

Janice Clark

Authorized Test Department Clerk

Description: 304/304L ANN .038-.042 AMS5513 PVC
Customer: GFI, Incorporated
Shipped: 02/17/2015
Heat: 504954

Size: 48 X 120
P.O.: D12016304
Part#:
Sales #: 01245391
Quantity: 1

UNITED PERFORMANCE METALS

This is to certify that in accordance with the records in our files the material shipped on your purchase order conforms to the following.

Irina Garrett
Irina Garrett

Manufacturer / Fabricante / Herstellerwerk

outokumpu



Type of document / Tipo de documento / Art der Prüfbescheinigung

INSPECTION CERTIFICATE

CERTIFICADO DE INSPECCION
ABNAHMEPRÜFZEUGNIS
according to / de acuerdo con / nach
EN 10204-3.1

Document number / N° de certificado / Bescheinigungs-Nr.

0000117503 / 2

Page / Pagina / Seite:

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1 ThyssenKrupp Drive; P.O. Box 13000; Calvert, AL 36513-1300

UNITED PERFORMANCE METALS, INC.
3475 SYMMES ROAD
HAMILTON OH 45015
USA

Customer/Ship to / Cliente / Besteller/Empfänger

UNITED PERFORMANCE METALS, INC, HAMILTON

Customer's order number / N° de Pedido Cliente / Kundenbestellnr.

01025466

Manufacturer's works order no. / N° de Pedido Manufactura / Werksauftragsnr.

901174078 / 001

Delivery note no. / N° de Entrega / Lieferanzeige Nr.

85319769 / 010

Product / Producto / Erzeugnis

COIL/BOBINA/BAND

Terms of delivery / Condiciones de entrega / Lieferbedingungen

ASTM A240/240M, ASME SA-240 Sec.II Part A Ed. 2013

ASTM A480/480M, ASME SA-480 Sec.II Part A Ed. 2013

ASTM A 666-10

SAE AMS 5513 J

SAE AMS 5511 H

SAE AMS 5516 P

PED 97/23/EC - Compliant

EN 10088-2

Steel grade and quality / Acero / Stahlsorte und Gütegruppe

Type 304L/304/302

UNS S30400

UNS S30403

UNS S30200

1.4307

1.4301

Customer's material no. /
N° de material del cliente /
Kundenmaterial-Nr.

Product dimensions (Thickness / Width / Length) /
Dimensiones (Espesor / Ancho / Largo) /
Maße des Erzeugnisses (Dicke / Breite / Länge)

Steelmaking procedure /
Proceso de manufact./
Herstellart

Finis /
Acabado /
Ausführung

1.02 mm x 1,219.20 mm
0.0401 inch x 48.0000 inch

AOD

11c 2B

Packing-No. /
N° de Empaque /
Paket-Nr.

No. of pieces /
Piezas /
Stückzahl

Actual weight /
Peso actual /
Ist-Gewicht

Coil No. /
Bobina No. /
Band-Nr.

Heat No. /
Colada /
Schmelzennr.

Sample Id. /
N° de muestra /
Proben-Id.

Sample Id. /
N° de muestra /
Proben-Id.

6223389

1

18,409 lb / 8,350 kg

746976

504954

1000249044

1000249045

Sum / Suma / Summe

1

18,409 lb / 8,350 kg

Heat /
Colada /
Schmelze

Country of heat /
País de colada /
Erschmelzungsland

Chemical composition / Composicion Quimica / Chemische Zusammensetzung

% C

% Si

% Mn

% P

% S

% Cr

% Mo

% Ni

% N

% Cu

504954

USA

0.028

0.38

1.33

0.029

0.0010

18.16

0.29

8.06

0.063

0.41

Sample Position /
Localiz. de la muestra /
Probenlage

TRANSVERSE

Inspection lot /
Lote de inspección /
Prüflot

YS0.2%

YS1.0

TS

E. A2"

HRB

Grain S

PSI / MPa

PSI / MPa

PSI / MPa

%

ASTM E

1000249044

39,159 / 270

43,945 / 303

92,530 / 638

59.3

82

8

1000249045

39,449 / 272

44,235 / 305

93,401 / 644

60.6

82

8

Resistant to intergranular corrosion / Resistente contra corrosión inter-granular / Beständig geg. interkrist. Korrosion: ASTM A 262 PRACTICE E - Sample Acceptable

OK

Dimensions-surface / Dimensiones-Superficie / Maße-Oberfläche:

Test of identity (spectrum analysis) / Control de identidad (análisis espectrográfico) / Verwechslungsprüfung (Spektralanalyse):

OK

Heat Treatment: Solution annealed 1920°F Min / Air cooled

Bending test O.K.

No welding or weld repairs were performed on this material

Grain Size as per ASTM E112

DFARS 225.872-1 Compliant

UPMOC

Review / Approved

Specs: At

By: *PI* Date: 12-10-14
#Pages: 2

Originator of the document / Originador del documento / Aussteller der Bescheinigung

Outokumpu Stainless USA, LLC

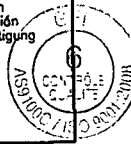
An ISO 9001: 2008 certified company
Quality Management System EU PED 97/23/EC certified

The information provided is a true copy of data on file /
Los valores mostrados corresponden a los datos archivados /
Die genotierten Werte entsprechen den gespeicherten Daten

Andrew Faucett

Andrew Faucett
Phone: +1 251 829 3492

Date of issue and validation
Fecha de emisión y validación
Datum Ausstellung / Bestätigung
12/04/2014



Certificate is generated automatically / Certificado es generado automáticamente /
Das Zeugnis wurde elektronisch erstellt

Name of expert / Nombre del experto / Name des Sachverständigen

Description: 304/304L ANN .038-.042 AMS5513 PVC
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Irina Garrett

Manufacturer / Fabricante / Herstellerwerk

outokumpu



Type of document / Tipo de documento / Art der Prüfbescheinigung

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CERTIFICADO DE INSPECCION
ABNAHMEPRÜFZEUGNIS
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EN 10204-3.1

Document number / 12/04/2014

Nº de certificado
Bescheinigungs

0000117503 / 2

Page / Pagina / Seite:

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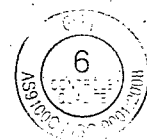
No intentional additions of Mercury compounds were made or used

Free of radioactive contamination

EU RoHS Directive 2011/65/EU Compliant

Product manufactured in the USA

Country of Heat as per ISO 3166-1



Originator of the document / Originador del documento / Aussteller der Bescheinigung

Outokumpu Stainless USA, LLC

An ISO 9001: 2008 certified company
Quality Management System EU PED 97/23/EC certified

Certificate is generated automatically / Certificado es generado automáticamente /
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Andrew Faucett

Andrew Faucett
Phone: +1 251 829 3492

Name of expert / Nombre del experto / Name des Sachverständigen

Date of issue and validation
Fecha de emisión y validación
Datum Ausstellung / Bestätigung
12/04/2014



180 Labrosse Av.
Pointe Claire, QC
H9R 1A1

TO:

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

(CPO) PO#:

PO27329



(POL) ITEM#:

0001



PACKAGE COUNT:

3 OF 3

(PNR) PART NUMBER:

D3602-1P



(SHQ) QUANTITY:

50



PACKAGE WEIGHT:

(UNT) UNIT OF MEASURE:

EA



(PSN) PACKING SLIP #:

0555557



(COO) ORIGIN:

CA



(NAF) NAFTA:



(TRA) TRACEABILITY #:

0298686-001

